

Date: Tuesday, 8/1/2006 11:25:36 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT X-TUBE EXT HEIGHT(-013)
 Job Number : 28052
 Estimate Number : 10563
 P.O. Number : *N/A* Part Number : D205596107
 This Issue : 8/1/2006 S.O. No. : *N/A* Drawing Number : D205596107
 Prsht Rev. : NC Project Number : N/A
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : A
 Previous Run : 24947 Material : *N/A*
 Written By : Due Date : 10/9/2006 Qty: 1 Um: Each
 Checked & Approved By : *06.08.01*
 Comment : Est Rev:D 05.03.21 Added bending procedure KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-107CHG001

See attached.

2.0 D2890 Aft Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

B28491D DP 6-9-19

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Mark 20.36" for cutting from tangential line in the straight section from D2890 as per Dwg wall template.

DP 6-9-19

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions. Conformity check and sign off by engineering.

06.09.19

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-107

DP 6-9-19

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

DP 6-9-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:25:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 28052

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up ends of the tube with Chemical Conversion Coat per QSI 005 4.1

MA 06 09 20

(1)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-09-20

8.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside with Immron per QSI 005 4.2

MA 06 09 20

(1)

9.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

06-09-20

(1)

10.0

D2856600

Abrasion Strip



Comment: Qty.: 1.6810 f(s)/Unit Total : 1.6810 f(s)

Pick:

Qty Part number

Description

Batch

2 D2856-600(10.09") Abrasion Strip

~~825594~~ 824328

RT 06-09-21

11.0

D29401

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2940-1

Support

~~825594~~ 825594

RT 06-09-21

12.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description

Batch

4 MS21920-28

Clamp

M100429

RT 06-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 24/07/16

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:25:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT X-TUBE EXT HEIGHT(-013)

Job Number: 28052

Part Number: D205596107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg D205-596-107. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

RT 06-09-20

A/R Sikaflex -291

N/A

Expiry date:

N/A

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 6-9-21

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-107

Location:

PPP Rev:

Rev C

Rev 8/22 (1)

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.09.22

Job Completion



W 06.09.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

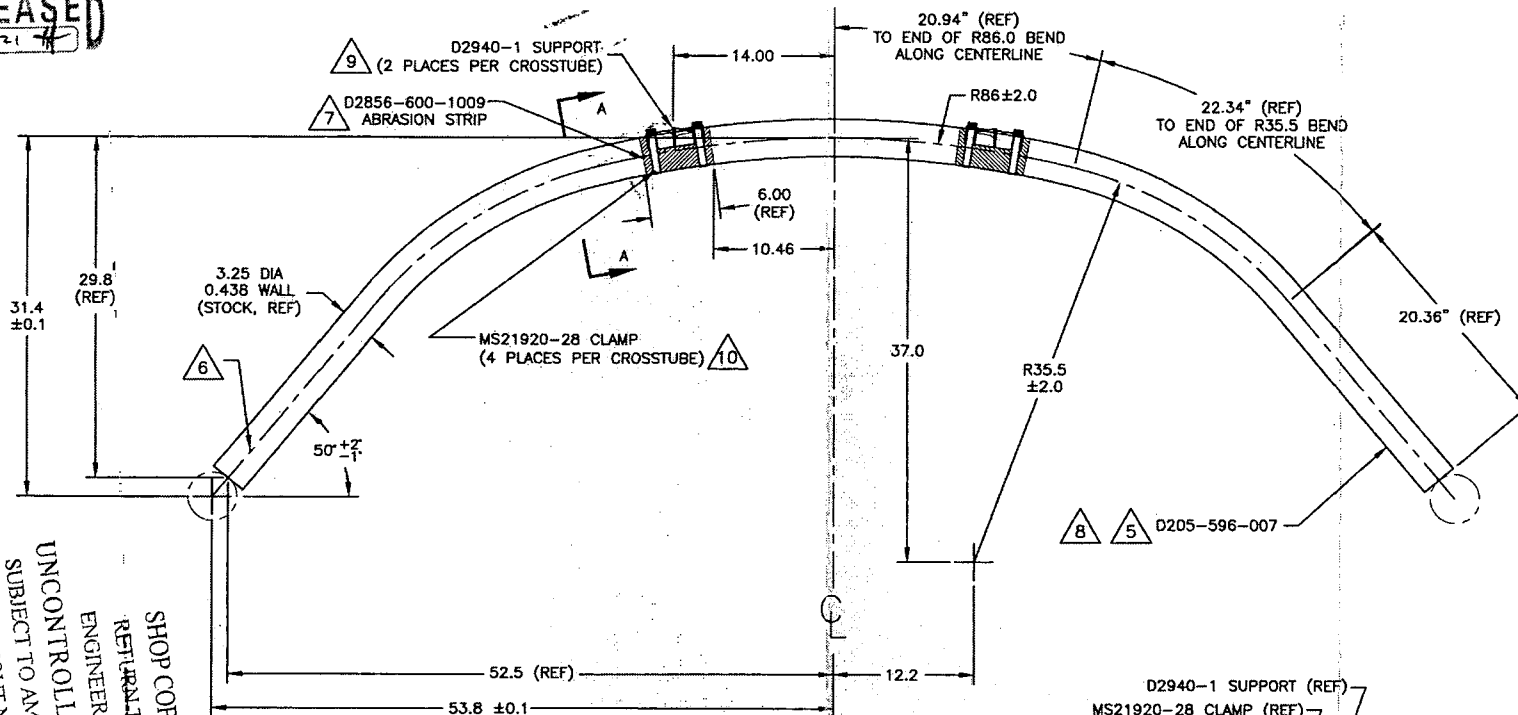
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

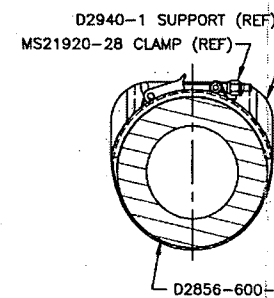
RELEASED
02.11.20



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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28052

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6008-180
FINISHED LENGTH = 127.28
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2940-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



SECTION A-A
SCALE 2:5

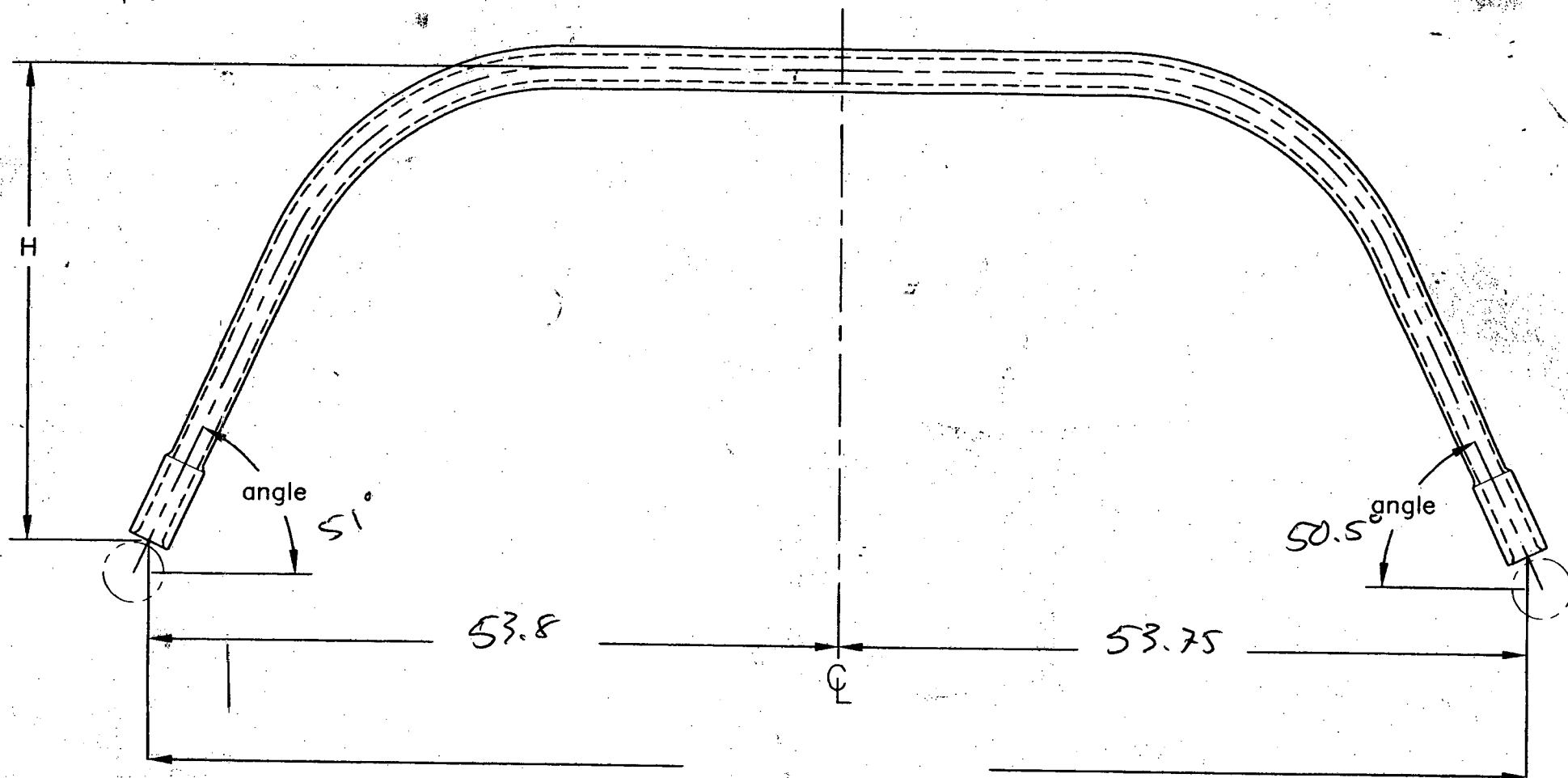
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A	02.11.20	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ENGLAND, CANADA
CHECKED	APPROVED	DRAWING NO. D205-596-107
DATE	02.11.20	TITLE CROSSTUBE AFT EXTENDED
		REV. A SHEET 1 OF 1 SCALE 1:10



tube "D"



DATE: 06.09.18

DESCRIPTION: D2890 (205-596-107)

BATCH NO: B28491 (to be used for B28052)

DRAWING: D2890

H: 31.4

1/2 SPAN: 53.80 / 53.750'

TOTAL SPAN: 107.55

ANGLE: 51° / 50.5°

06.09.18

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 First Issue : / / Type : LANDING GEAR Drawing Number : D205596107
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 Due Date : 10/9/2006 Qty: 1 Um: Each
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Additional Product

Job Number:



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06.08.04

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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2890 Aft Crosstube

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REFERENCE ONLY